

# EUROPEAN PATENT OFFICE

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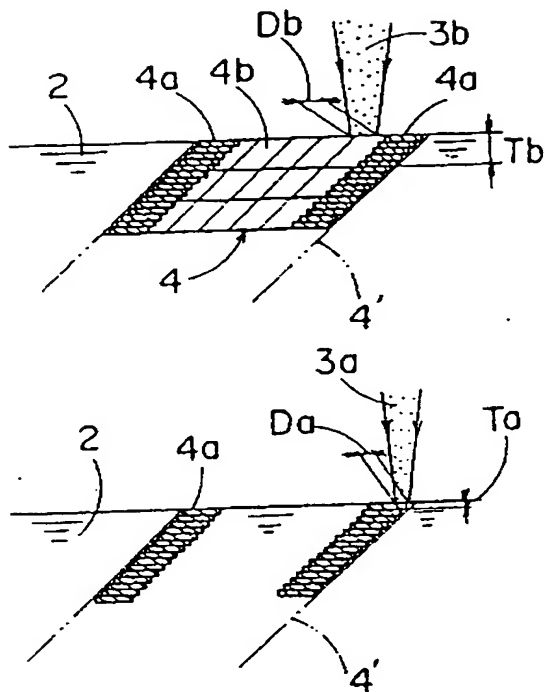
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TITLE : FORMING METHOD OF THREE  
DIMENSIONAL SHAPE



ABSTRACT : PURPOSE: To obtain a molding being excellent in both of the smoothness of an outer surface side and molding efficiency by forming the outer surface side of a three dimensional shape, independently of the part being far inner therefrom, in putting optically curable layers thinner than the inner part.

CONSTITUTION: Within a three dimensional shape 4' to be formed, a light beam 3a is irradiated on only part equivalent to an outer surface so as to form the optically cured layer 4a of an outer surface side part. The thickness Ta of the optically cured layer 4a of the outer surface side part is formed to be extremely thinner than that of the thickness Tb of an inner part optically cured layer 4b in accordance with the smoothness of the outer surface required in a molding 4. Next, an optical beam 3b is irradiated on the inside of the optically curable layer 4a of the outer surface side in order to form an inner part optically cured layer 4b. The thickness Tb of the inner part optically cured layer 4b is set to be an appropriate thickness in consideration of a molding efficiency, and thus, it is thicker considerably than the optical cured layer 4 of the outer surface side part. The thickness Tb of the inner part optically cured layer 4b and the thickness Ta of the optically cured layer 4a of the outer surface side part can be set freely in consideration of the smoothness of the outer surface and the molding efficiency.

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